	er ID 119539 2014 1:05:57 PM		*119	9539*						Pa	ge 1
Item ID: Revision ID: Item Name:	D3592-1 Plate		Accept	*N900	0040	100)* ·	Setup Star Stop	17	S13	
Start Date: Required Date: Reference:	5/15/14 Start Qty: 2	,		Cust Item Customer:					I		
Approvals:	Process Plan:MU5	Date:_\\\\ _\\\\\\\\\\\\\\\\\\\\\\\\\\\	Tooling: SPC (Y/N):		Oate:	 .	I	Run Star Stop	^ <i>\</i>	R13	_
Sequence ID/ Work Center II	Operation Description	·	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamj	
Draw Nbr	Revision Nbr										
D3592	Rev B										
100 *100 Waterjet	FLOW WATER J		0.00				25	0		DAS 23 9-89	1409-29
FLOW CNC Waterj	et 1-Cu ***** Dwg Prog	t as per Dwg D3592 *ENSURE GRAIN IS AT 45 DEC Rev:	G AS PER DEO D3592-I	b-1***** •							

0.00

0.00

110

*11**0***

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

DQA:			Date:										`DART
QA Closed:			Date:			WORK ORDER NON-	-CC	JNFOI	RMANCE / U		Vork Order uj	odate only	AEROSPACE
						DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Work Orde	er: _								G1:14.15.1	C	7	Water Jet	Engineering
Part N	lo					Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing	_	d. Eng. Coor.	Quality Other
NCR N	lo					Suspected Unapproved		Incir	Large Fab	Composite		Supplier	
Root		,			Desci	ription of work order update	1	nitial	Act	tion′	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling											1		
Handling/Pre			:			-							
Material													
Operator	- :	٠.											
Offset/Setup		•											
Process											Ì		
Supplier	コ												
Training											İ		
Transport													
Unapproved	\Box												
* . •		-					FAI	ULT CA	EGORY				
Landir	ng G	ear				General				_			-
		Bending				Bend		Folio/F	rogram		Outside Dim	ensions	Pressure/Forced
		Centre No	t Concer	ntric		BOM/Route		Grain		L	Over/Under	tolerance	Set-up
•		Cracks				Broken/Damage/Defect		Hardwa	re	L	Part Incorre	cí	Temperature/Cure
		Crimp/Kin	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	nqualified	Part Lost/M	issing	Weld
		Cuffs				Contamination		Instruct	ions Incomplete/	Unclear	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong	_
		Heat Trea	t			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
ľ	$\overline{}$	Inspection		Tube		Drawing		Misrea	d	_			
ľ		Marks/Ch	•			Drill Holes		Off-set					
ľ	_	Turning Se				Finish		Out of	Calibration				
ļ	_	Wave/Tw		e		Fit/Function		Out of	Sequence				

Work Orde Friday, May 16,				*119	9539*							Page 2
	D3592-1 Plate 5/15/14	Start Qty: 20.00	*20	Accept ★	*N900		100) *	Setup	Start Stop		S1* S2*
Required Date: Reference:	5/15/14	Req'd Qty: 20.00	*20	*	Customer:			_		C44		
Approvals:	Process Pl	an:	Date:	Tooling:	D	ate:		ŀ	Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	D:	ate:				Stop	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID		Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
120		QC8- Inspect parts - seco	nd check	0.00				6				DAS 38 ,,, a
120 QC Quality Control		Мето		0.00				(25)	<i>)</i>			9-89 / /- 6
Quanty Control												
130		G. MD.		0.00		DA 30		3 /				,,,),
120 Small Fab		Small Fab Memo		0.00		9-8		20			.	(4

140

Small Fab

QC5- Inspect part completeness to step on W/O

Form as per Dwg D3592 using DT8949

0.00

140 Quality Control

Memo

0.00

DAS **38** 9-89

NOV 1 2 2014

DQA:			Date:				-	201501	2444405 / 115	D 4 TF				`DART
QA Closed:			Date:			WORK ORDER NON-	-C(JNFO	RMANCE / UP		Wor	k Order up	date only	AEROSPĀCĒ
						DISPOSITION						ARTMENT/		
Work Orde	er: _			·		DISPOSITION				AGAII131 1		-11111112117	٠	, ,
						Rework			Skid-tube	Crosstube	_		Water Jet	Engineering
Part N	lo					Scrap			Machining	Small Fab	_		d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing	_	Rec/Stor	e/Packaging	Other
NCR N	۱o		,			Suspected Unapproved			Large Fab	Composite			Supplier	
Doot	· 1		i		Doss	ription of work order update		nitial	Actio	n n	\top	Sign &		
Root		Date	Ston	Qty	Desci	or non-conformance		iief Eng	Descrip			Date	Verification	QC Inspector
Cause	\dashv	Date	Step	Qty		of non-comormance	CII	ilei Liig	Descrip	70011		Dute	Vermeation	Q0 mspector
Design Doc/Data	一												•	
Equip/Tooling	\dashv													
Handling/Pre	_				-									
Material														1
Operator	\dashv													
Offset/Setup	ヿ										ł			
Process														
Supplier														
Training				:										
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Unapproved														
							FAI	ULT CA	regory					······
Landi	ng G	ìear				General		•		-	_		_	٦ .
		Bending				Bend		•	Program		_	Outside Dime		Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain		}.	_	over/Under	_	Set-up
		Cracks				Broken/Damage/Defect		Hardwa		1	_	art Incorrec		Temperature/Cure
		Crimp/Kir	ık/Ripple	/Wave		Burrs	<u> </u>	1	ion Incomplete/Unq	F		art Lost/Mis	ssing	Weld
		Cuffs			ļ	Contamination	_	4	ions Incomplete/Un	nclear	_	art Moved		Wrong Stock Pulled
	-	Crushing			-	Countersink		1	ned/off center		-	ositioned W		1
	_	Heat Trea				Cut Too Short	_	Mislabe		į	P	ower Loss/S	Surge	Other
	-	Inspection	•	Tube	<u> </u>	Drawing	<u> </u>	Misread			_			
	-	Marks/Ch			<u> </u>	Drill Holes	L	Off-set			_			
	-	Turning S			<u> </u>	Finish	L	4	Calibration		_			
		Wave/Tw	ist in Tub	oe -		Fit/Function		Out of S	Sequence					

e . 1

Work Order ID 1195	539	
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Memo

QC

Quality Control

119539

Page 3

Friday, May 16, 2014 1:05:57 PM Accept *N900040100* Setup Start D3592-1 Item ID: **Revision ID:** Stop **Item Name:** Plate *20* **Cust Item ID: Start Qty: 20.00** 5/15/14 **Start Date: Customer: Req'd Qty:** 20.00 *20* Required Date: 5/15/14 Reference: Start Run **Tooling:** Date: Process Plan: Date: Approvals: Stop Date:_ SPC (Y/N): Date:_____ QC: _____ Tool # Plan Reject Reject Insp. Tool ID Accept Operation Set Up/ Sequence ID/ Number Stamp Code Qty Qty Run Hours Description **Work Center ID** Identify as per dwg & Stock Location: WHO 3 0.00 150 *150* 0.00 Packaging Memo *** STOCK IN STEP CELL*** Packaging QC21- Final Inspection - Work Order Release 0.00 160 *160* 0.00

DQA:			Date:												TRAGE"
						WORK ORDER NON-	-CC	ONFO	RMANCE / U					_	AEROSPACE
QA Closed:			Date:			·	_				wor	k Order up	date only		
Work Orde	٠r٠					DISPOSITION				AGAINST	DEP.	ARTMENT	PROCESS		
Work Orde	-					Rework			Skid-tube	Crosstube			Water Jet	٦	Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	┪	Quality
	-					Use-as-is			noforming	Finishing			e/Packaging	٦	Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite			Supplier		
	_														
Root					Desci	ription of work order update	I	nitial	Act	tion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	_	Date	Verification	4	QC Inspector
Design															
Doc/Data	_					•									
Equip/Tooling	_														
Handling/Pre															
Material			·												
Operator															
Offset/Setup															
Process															
Supplier	_														
Training															
Transport															
Unapproved							5 4 1	UT CAS	I CORV			-			
1							FAU	JLI CA	regory						
Landir [$\overline{}$					General Bend		احمانه (۵	rogram	Г	\Box_{ϵ}	Outside Dim	ensions [٦,	Pressure/Forced
}		Bending Centre No	t Cancar	atric	\vdash	BOM/Route		Grain	rogram	}		Over/Under	<u> </u>	_	Set-up
-		Cracks	or concer	itiic	-	Broken/Damage/Defect		Hardwa		 	_	art Incorrec	<u> </u>		Temperature/Cure
		Crimp/Kin	k/Rinnle	/\ <i>M</i> /ave		Burrs			ion Incomplete/Ui	ngualified		art Lost/Mi	<u></u>		Weld
}	_	Cuffs	ik/ Nippie	, wave		Contamination		1	ions Incomplete/l			art Moved	- F		Wrong Stock Pulled
}		Crushing			-	Countersink		i	ned/off center		_	ositioned V	ـــ rong/		
ŀ		Heat Trea	t			Cut Too Short	-	Mislabe		ţ	-	ower Loss/		\neg	Other
ł		Inspection		Tube		Drawing		Misread			'		~ L		
}		Marks/Ch				Drill Holes	\vdash	Off-set			-	···			
	\dashv	Turning Se				Finish		1	Calibration		-				
	-	Wave/Tw				Fit/Function		1	Sequence		_				

Picklist Print

Friday, May 16, 2014 1:06:03 PM

Work Order ID: 119539

119539

Parent Item:

D3592-1

D3592-1

Parent Item Name: Plate

Start Date: 5/15/14

Required Date: 5/15/14

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A

New Issue 07-03.26 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No		100	sf	178.2330	0.139	- 2.9263 T6			DAS 23 14

M6061T6S 125

6061-T6 .125 Sheet

Location	Loc Oty	Loc Code	
MAT021	178.233		
m127272	36.5		
m127454	63.333		
m127501	14.4		
m128852	64		128852.

Page 1

DQA:			Date:			•							TRACC
						WORK ORDER NON-	-CC	ONFO	RMANCE / U				AEROSPACE
QA Closed:			Date:			<u></u>	_			V	Vork Order up	date only	
Work Ord	er.					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
WOLK OF G	-	-	-		_	Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	۷o.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as-is			noforming	Finishing		e/Packaging	Other
NCR I	No.					Suspected Unapproved			Large Fab	Composite		Supplier	
								,					
Root ∗	ı				Desc	ription of work order update	ı	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material	Н												
Operator	Н												
Offset/Setup	_												
Process	Н												
Supplier	\vdash												
Training Transport	Н												
Unapproved	Н		i i										
опаррточеа	LL		<u> </u>	<u> </u>	<u> </u>		FAI	JLT CAT	EGORY				J
Landi	ng G	iear				General						-	<u>, </u>
		Bending				Bend		Folio/P	rogram	Γ	Outside Dim	ensions	Pressure/Forced
	$\boldsymbol{\vdash}$	Centre No	t Concer	ntric		BOM/Route		Grain	J		Over/Under	tolerance	Set-up
	П	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	ri 🗀	Temperature/Cure
	П	Crimp/Kir	k/Ripple	/Wave		Burrs		Inspecti	on Incomplete/U	nqualified	Part Lost/Mi	ssing	Weld
	П	Cuffs				Contamination		Instruct	ions Incomplete/	Unclear	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned V	/rong	,
		Heat Trea	t			Cut Too Short		Mislabe	led		Power Loss/	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misread	i				
		Marks/Ch	atter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of (Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence				

DART AEROSPACE LTD	Work Order:	9539
Description: Bracket	Part Number:	D3592-1
Inspection Dwg: D3592 Rev: B	P	age 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

XF	irst Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	01129			V	Jemo,
Ø0.098	+0.004/-0.001	0.098	-		V	
0.506	+/-0.010	0.506	_		V	
0.256	+/-0.010	0.256	_		J	
0.756	+/-0.010	0.7%	,		V	
3.256	+/-0.010	3.756	_		U	
0.262	+/-0.010	6.262	-		U	
1.993	+/-0.010	1.993)		V	
3.341	+/-0.010	3.341	_		U	
3.641	+/-0.010	3.6412	_		V	
3.897	+/-0.010	3.857			L	
3.762	+/-0.010	3.762"	1		L	
		71				
		-				
			DAS			

	DAS		38₄		
Measured by:	23 9-89	Audited by:	99889	Prototype Approval:	N/A
Date:	14-09-29.	Date:	14-9-29	Date:	N/A

Rev	Date	Change	Revised by Ap	proved
Α	07.10.15	New Issue	KJ/EC/DD	



DESIGN DRAWN BY DART AEROSPACE LTD 00 HAWKESBURY, ONTARIO, CANADA CHECKED APPROYED DRAWING NO. REV. B D3592 SHEET 1 OF 1 DATE TITLE **SCALE** 07.05.31 **PLATE** 1:1

07.01.15 Α **NEW ISSUE** DEO ATTACHED В 07.05.31 **TOOLING HOLES ADDED** Ø0.129 (DRILL #30) (2 PLACÈS) R0.25 (TYP) -(OPTIONAL TOOLING HOLE) 3.762 -3.762 UNCONTROLLED COFY SUBJECT TO AMENUMENT 3.506 3.506 ENGINEERING 3.256 (REF) 3.256 3.006 3.006 2.756 D3592-1F GRAIN DIRECTION **FLAT PATTERN** Ø0.098 (DRILL #40, TYP 16 PLACES) 1.006 0.756 0.756 0.506 (REF) -0.506 0.256 0.256 0 UNDER BEVIEW 0 641 RELEASED 07.06 30 2.222 FORM TO MATCH D2622 EXTRUSION BEND DETAIL SCALE 1:2 2.340 R2.085 (REF) ē

MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125" THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.125)

R0.585 (REF)

D3592-1 PLATE

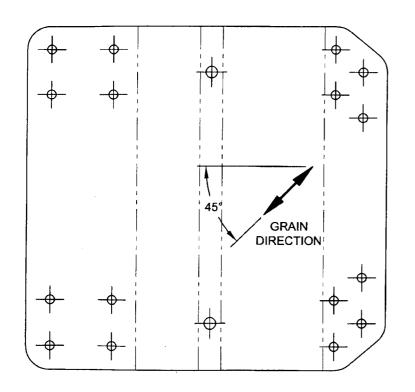
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED 5) BREAK ALL SHARP CORNERS 0.010 MAX

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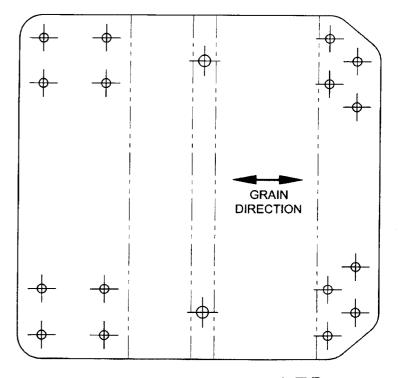
DRAWING	NO.	TITLE		REV. B	DART AEROSPACE L	D.E.O. NO.		SHEET NO.	SCALE
D3592		PLATE			ENGINEERING ORDE	R D3592-B-1		SHEET 1 OF 1	NTS
DRAWN	AJS		CHECKED	نا	MFG. APPR.	APPROVED	Not	DE APPR.	
DATE	08.09.	11	DATE 08 Oci	il	DATE 08/09/11	DATE OCIC	9/11	DATE 08 09 11	· · · ·

MODIFY GRAIN DIRECTION AS SHOWN BELOW TO PREVENT CRACKING WHEN WELDING AT ASSEMBLY (SEE CAR 08-026).

<u>IS:</u>



WAS:



ALL OTHER INFORMATION REMAINS UNCHANGED

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